



Operating Instructions

CHM

Crimp Height Measuring Device

Edition 1, 09/2006

Table of Contents

1. General Information	3
1.1 Explication of Symbols	3
1.2 Product Description	3
1.3 Technical Information	3
2. Operation Instructions	4
3. Dial Gage	
3.1 Operation	5
4. Overview of the System	5

1. General Information

1.1 Explication of Symbols



This symbol refers to tips and tricks of the Technical Service Center. It further includes other information to be observed.

1.2 Product Description

The KMF CHM is designed for measuring the crimp height of wire as well as insulation crimps. The measuring contacts of this device were developed especially for this purpose.

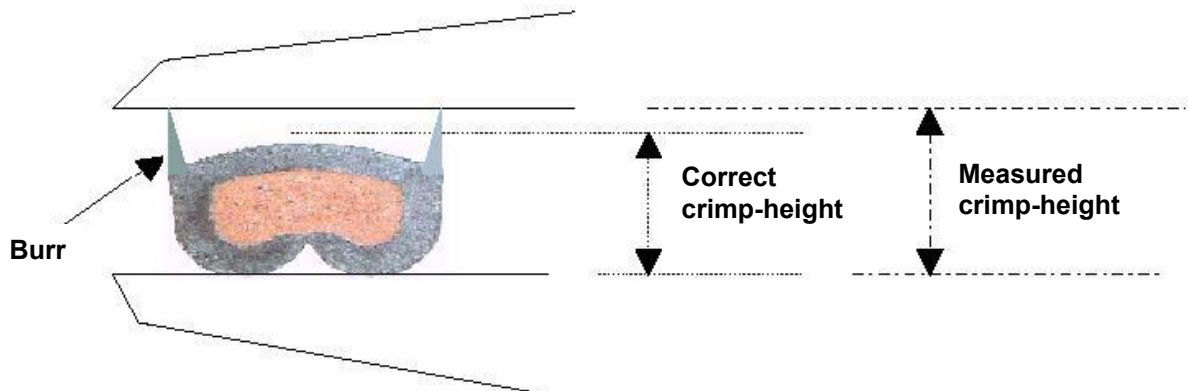
The contacts are provided with a spring which ensures a constant pressure during the measurement. A constant measurement is thereby guaranteed – irrespective of the user.

1.3 Technical Information

Operating voltage	5V DC 40 mA
Dimensions	155 mm (L) x 125 mm (W) x 235 mm (H)
Weight	Approx. 3,500 g
Interface	RS232
Real-time clock	Mitutoyo 543-691B Digimatic, 0.001, mm

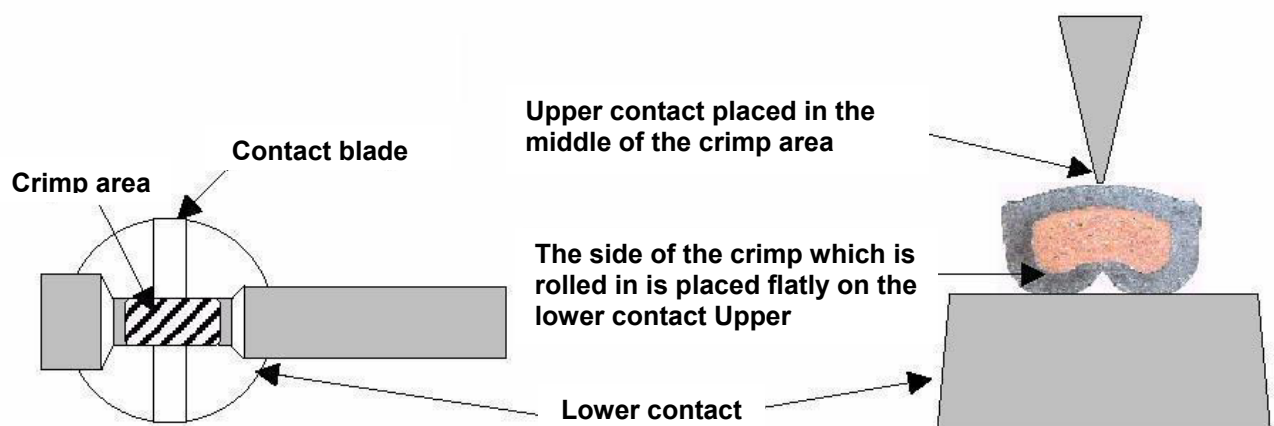
2. Operating Instructions

It is to be ensured that the crimp height measurements are effected correctly. The crimp height measuring device includes a flat contact blade on the one side and a precise contact on the other. The precise contact serves the avoidance of faulty measurements in case of objects which are soiled with burr. Normal callipers would also measure the burr entailing a falsification of the measuring result.



The measuring object is to be positioned in a way that the side of the crimp which is rolled in is diagonal to the blade contact and at right angles to the edge of the lower contact. Furthermore, the object is to be placed horizontally on the edge. Tilted objects may falsify the measuring result.

The upper precise contact is to be positioned exactly in the middle of the crimp in order to measure the highest point of the crimp. If the upper contact is not placed exactly in the middle of the crimp area, the measuring result may be falsified.



The object must be at right angles to the edge of the lower contact and rest on it horizontally. The upper contact point is to be positioned exactly in the middle of the crimp.

3. Dial Gage

3.1 Operation

- Switch on the gauge by actuating the ON/OFF button.
- By means of the +/- keys, you can switch between the normal mode in case of which the display counts up and the reverse mode in case of which the display counts down (REV). Make sure that the gage is always in the normal mode.
- By pressing the ORIGIN key (longer than 1 second), the zero point is set at the current position.

4. Overview of the System

